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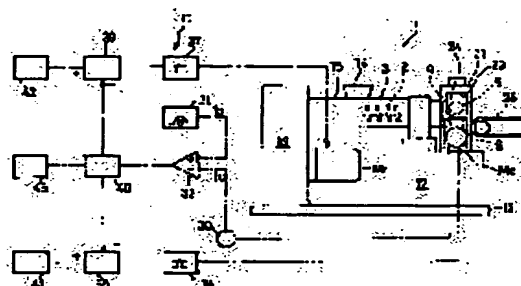
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(54) CONTROLLING METHOD FOR BANK AMOUNT OF ROLLER HEAD RUBBER EXTRUDER

(57)Abstract:

PROBLEM TO BE SOLVED: To provide a method for controlling bank amount of a roller head rubber extruder in which bank amount of rubber between a rubber extrusion port of the body of the extruder and calendering rolls is stabilized.

SOLUTION: The roller head rubber extruder is equipped with the body 3 of the extruder having a screw 2 for extruding rubber, the upper and lower calendering rolls 5, 6 arranged near to the rubber extrusion port of the body 3 of the extruder and a guiding means which incorporates a side guide performing width decision of rubber extruded from the rubber extrusion port in the interval reaching the calendering rolls 5, 6 and forms a closed bank surrounding the rubber extrusion port and leading rubber. In the controlling method for bank amount, speed of rotation of the screw 2 or speed of rotation of the calendering rolls 5, 6 is regulated by detecting calender current of a calender motor Mc for driving the calendering rolls 5, 6 and comparing the detection value with preset value. Thereby, bank amount is stabilized.



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